

# Work Order ID 68705

Wednesday, April 20, 2011 8:34:42 AM



Page 1

Item ID:	D3438-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Weldment Assembly					
Start Date:	4/20/2011	Start Qty:	2.00	Cust Item ID:		
Required Date:	4/25/2011	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	4-20-2011	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3438	Rev A								

100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1-Cut D2244 to 79.63" at 34° as per Dwg D3438 2-Deburr ends 3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg D3438 using DT8343								
	4-Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

11.05.06 2 2 2E11/05/09

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68705**

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Item ID: D3438-042

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Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				2	0	MR 11/05/10	
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				2	BL	11-5-10	
150  Large Fab Large Fab	Large Fab  Memo Weld last cap per dwg D3438 & grind flush	0.00  0.00				2	0	11.05.11	

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**Work Order ID 68705**

Wednesday, April 20, 2011 8:34:43 AM



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Item ID: D3438-042

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Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

~~QC~~ Inspect visual per QSI004- Fusion Welds

0.00

BLU

8

Memo

0.00

Sulashy

Pro →

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulashy

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

I-Touch up alodine ☐ START TIME:

TEMPERATURE:

FINISH TIME:

☐ OVEN1:20  
3200

1:50

2X ~~Ø~~ m/f 11/05/12

M 116964

Dart Aerospace Ltd

W/O: 68705		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/05/14	#160	Perm. change. change to QC 10 inspection	AD	11.05.16			8 11/05/14

Part No: D3438-042 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190



HandFinish

Hand Finishing

HandFinishing

Memo

Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs

0.00

0.00

2X ~~Ø~~ M/L 11/05/12

200



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

2 BL 11-5-12

210



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

RRP  
68700

0.00

0.00

P/L 11/7/12 ②

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 68705**

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Item ID: D3438-042

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Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16 [Signature]  
MF  
11-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 20, 2011 8:34:49 AM

Page 1

Work Order ID: 68705

Parent Item: D3438-042

Parent Item Name: Step Weldment Assembly

Start Date: 4/20/2011


Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00


Comments: IPP A 05.05.18 New Issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2244-116  Step Extrusion		Manufactured	No			100	Each	158.0000	1	2		<i>11.05.06</i>	
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Location	Loc Qty	Loc Code
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HALL	94	
60307	94	
WA	64	
57850	18	
60307	46	

D2561  Lug		Manufactured	No			100	Each	9.0000	2	4		<i>11.05.06</i>	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	-----------------	--


Location	Loc Qty	Loc Code
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WA015	9	
<u>66813</u>	9	

D2673-34  End Plate		Manufactured	No			100	Each	101.0000	2	4		<i>11.05.06</i>	
---	--	--------------	----	--	--	-----	------	----------	---	---	--	-----------------	--

Location	Loc Qty	Loc Code
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WA015	101	
<u>59690</u>	101	

D2564  Mounting Angle		Manufactured	No			110	Each	25.0000	2	4		<i>11.05.06</i>	
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Location	Loc Qty	Loc Code
----------	---------	----------

WA	25	
<u>66984</u>	25	

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**DART**

DESIGN	RF	DRAWN BY	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3438
DATE	05.05.09			TITLE STEP WELDMENT ASSEMBLY
				REV. A SHEET 1 OF 1 SCALE 1:1
A		05.05.09		NEW ISSUE

RELEASED

05.05.09

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ENGINEERING

UNCONTROLLED COPY

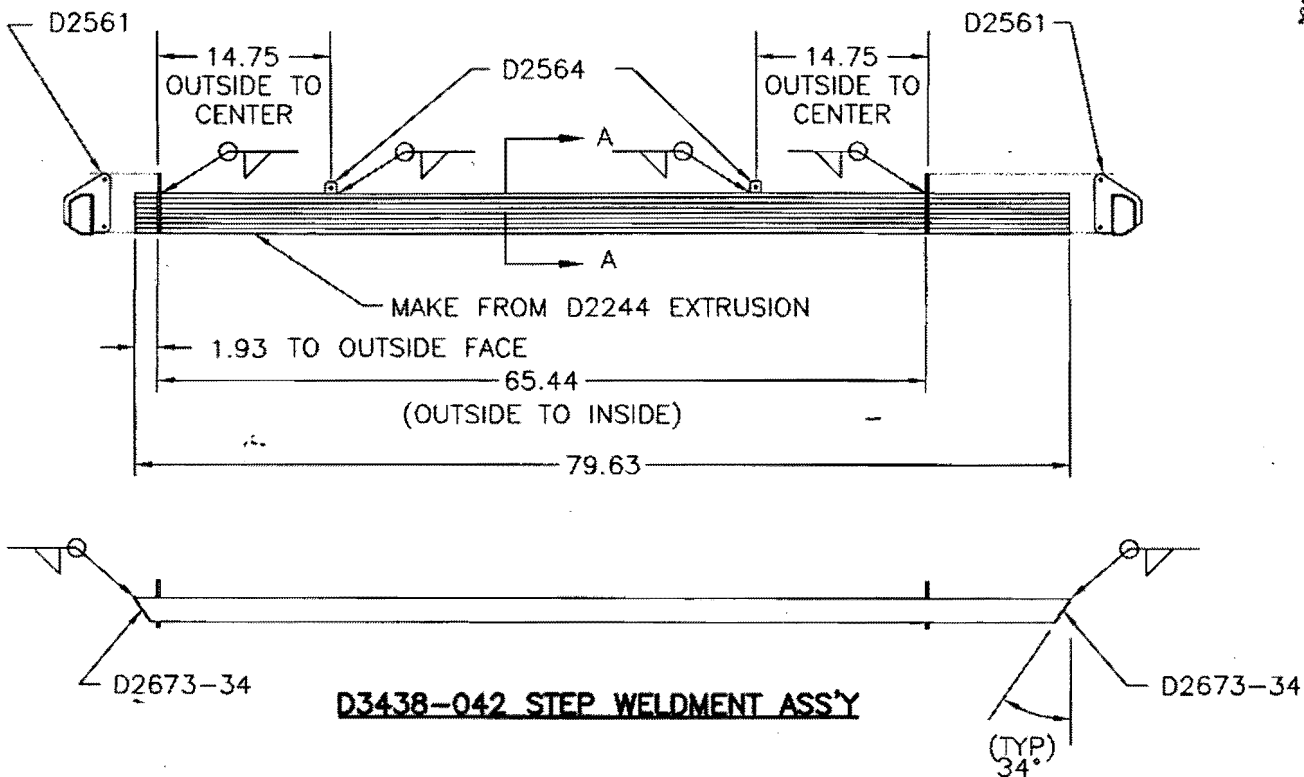
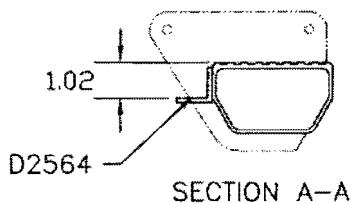
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 65705

02/11-04-20



**D3438-042 STEP WELDMENT ASS'Y**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1  
WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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